



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13293 ✓	36/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No - 12501 Rad
3	Pallet Die No.		12573 (4.0mm)	
4	Die Category	Drg. No.	M-Jumbo	Step length - 2.0mm
5	Out Side Diameter	Drg. No.	700mm Step OD - 693mm	Taper - 12°
6	Inside Diameter	Drg. No.	600.12mm ✓	
7	Width of Pellet Die	Drg. No.	910mm 910mm	
8	Grooves as per Drawing	Drg. No.	12x8x7mm / 12x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640mm ✓	
13	Tapping Hole Diameter		M to check by M to Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 16/11/24

1	As per programme no.		—	
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5mm	outside (3-3)	Innel					
3	External Relief Depth		18mm	14mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		16	11	24				

Inspected By (Sign) & Date Ramanpreet Singh 16/11/24

Singh
18/11/24

Reviewed by (Engineer-CNC)

Manager-QA